

Item ID: D2850-1

Accept

**Setup Start**

Revision ID:

Item Name: End Bracket

Stop



Start Date: 4/14/2011 **Start Qty:** ~~1~~ 0.00

Start Qty: ~~1~~ 0.00

**Cust Item ID:**

Required Date: 4/21/2011 **Req'd Qty:** 10.00

Req'd Qty: 10.00



Customer:

Reference:

Approvals: **Process Plan:**

Date: 1-04-14

Tooling:

Date:

Run Start



QC:

Date: _____

SPC (Y/N):

Date:

Stop

[illegible]

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 68490

Thursday, April 14, 2011 10:13:36 AM



Page 2

Item ID: D2850-1

Accept



Setup Start



Revision ID:

Item Name: End Bracket

Stop



Start Date: 4/14/2011 Start Qty: 10.00



Cust Item ID:

Required Date: 4/21/2011 Req'd Qty: 10.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC8- Inspect parts - second check

0.00

JK 11-08-09



QC

Memo

0.00

Quality Control

8

140

Identify as per dwg & Stock Location: WA

0.00



Packaging

Memo

0.00

JK 11-08-10

Packaging

*** STOCK IN STEP CELL ***

8

150

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

CK 11/08/11

11-08-10 (4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Monday, July 18, 2011 10:59:10 AM

Page 1

Work Order ID: 68490

Parent Item: D2850-1

Parent Item Name: End Bracket



Start Date: 4/14/2011

Required Date: 4/21/2011

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP B 98.12.07 Changed folio DM :

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B2.500X01.50 0		Purchased	No				f	36.0000		3.2			



6061-T6 Bar 2.50 x 1.50



Location

Loc Qty

Loc Code

MAT010

36

16742

36

M107 387 X ~~387~~
2701

ant 10/08/03

DART AEROSPACE LTD		Work Order:	68490
Description: High Float Step End Bracket		Part Number:	D2850-1
Inspection Dwg: D2850 Rev: A		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.720	+0.000/-0.030	1.720	✓		Vern	GA-01
0.178	+/-0.010	0.176	✓		H-G	31006
0.10	+/-0.030	0.099	✓		Vern	GA-01
30.0°	+/-0.5°	30°	✓		Angle prot.	MLL-CBB
2.15	+/-0.030	2.152	✓		Vern	GA-01
0.375	+/-0.010	0.372	✓		"	"
0.125	+/-0.010	0.123	✓		"	"
1.00	+/-0.030	1.003	✓		H-G	31006
R0.125	+/-0.010	R0.125	✓		R-G	ref.
19.2°	+/-0.5°	19.2°	✓		Angle prot.	MLL-CBB
0.125	+/-0.010	0.131	✓		Vern	GA-01
0.750	+/-0.010	0.754	✓		"	"
0.600	+/-0.010	0.598	✓		H-G	31006

Measured by: A.A	Audited by: SL	Prototype Approval:	N/A
Date: 11/08/08	Date: 11-08-09	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	06.06.05	New Issue	KJ/JLM	

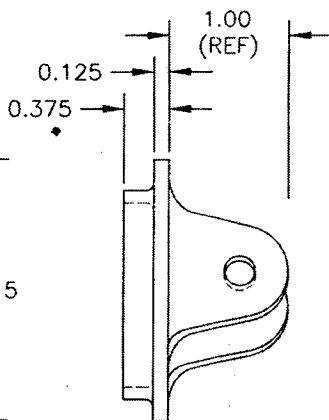
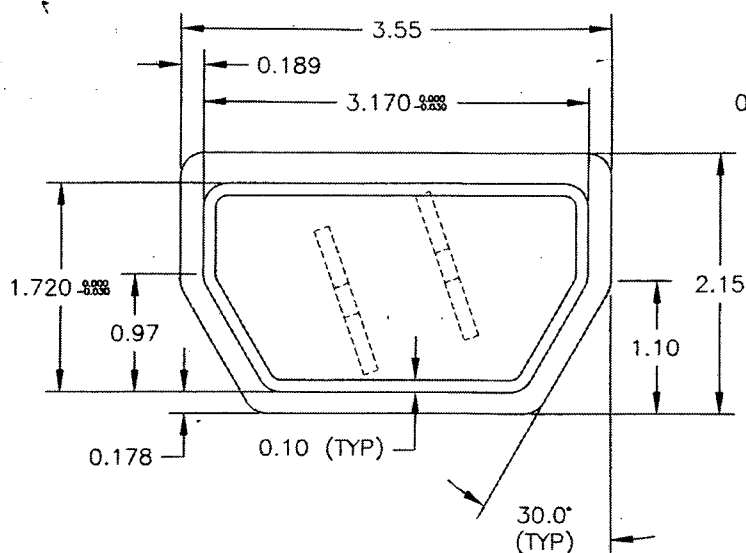
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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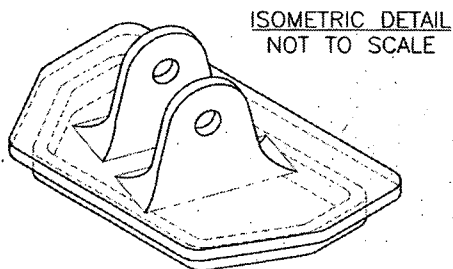
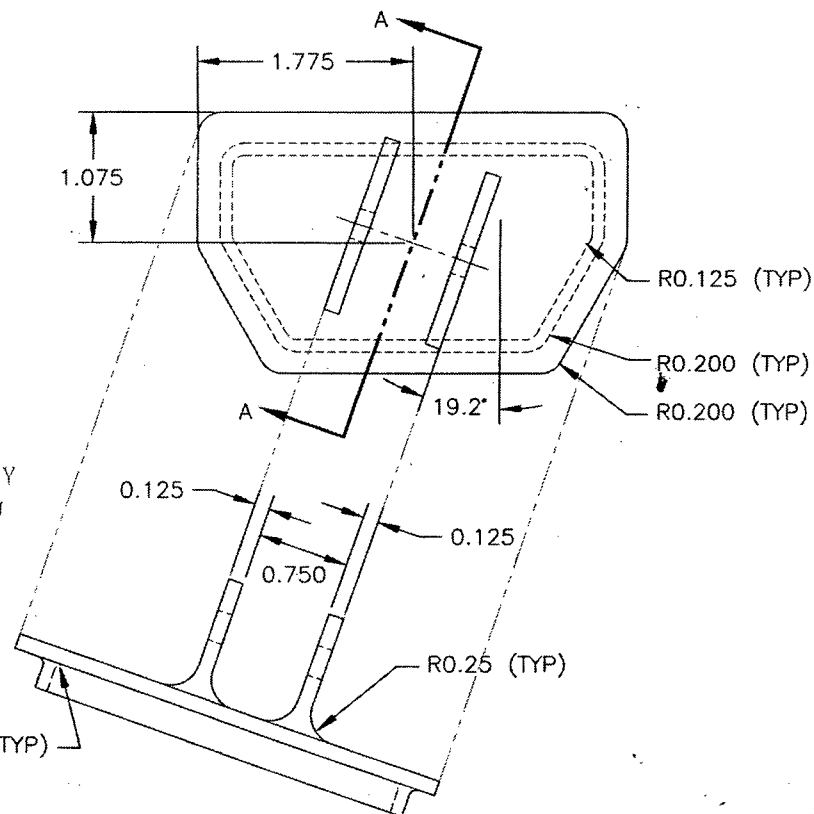
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 68490

D2850-1 (SHOWN)
D2850-2 (OPPOSITE)

MATERIAL: 6061-T6 (QQ-A-200/8 OR QQ-A-250/11 OR QQ-A-225/8)

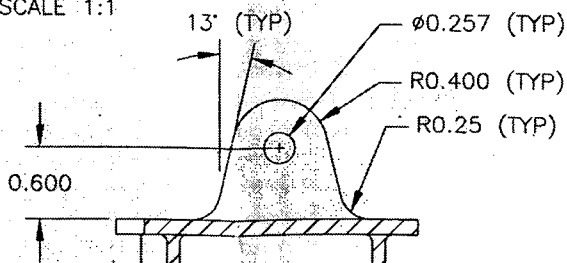
FINISH: NONE

BREAK ALL SHARP EDGES 0.010 TO 0.020
TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED



ISOMETRIC DETAIL
NOT TO SCALE

SECTION A-A
SCALE 1:1



RELEASED
25/12/98 Rb

A	98.11.10	NEW ISSUE, REPLACES D2357 REV. A AND D2358 REV. B	
DESIGN	CP	DRAWN BY	CP
CHECKED	KE	APPROVED	#
DATE	98.11.10	DRAWING NO.	D2850
		TITLE	HIGH FLOAT STEP END BRACKET
		SCALE	1:1

W/O:		WORK ORDER CHANGES					
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